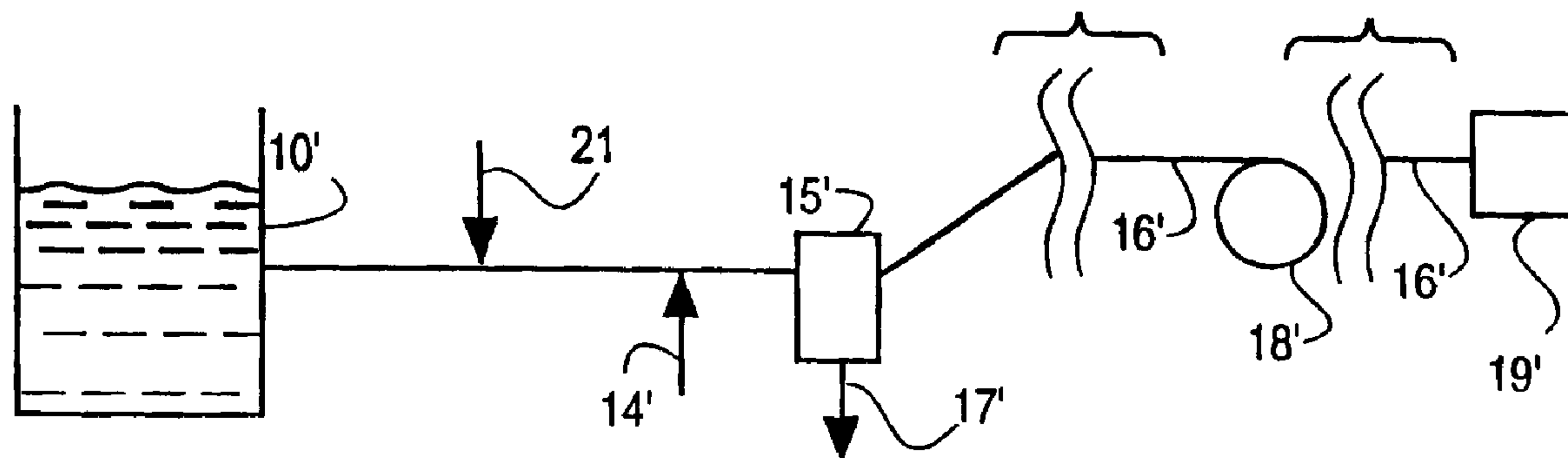




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(54) Titre : METHODE DE FABRICATION D'UNE BANDE CONTINUE DE PAPIER  
 (54) Title: PROCESS FOR PREPARING A PAPER WEB



(57) **Abrégé/Abstract:**

Disclosed is a process for preparing a paper web. The paper web is prepared from a low-grade furnish, which contains low-grade pulps, such as recycled pulp and/or groundwood pulp, and which, in the preferred embodiment, is a newsprint furnish. In accordance with the disclosed process, a pre-flocculated filler is added to the furnish prior to forming the paper web from the furnish. Filler will be retained in the web; and retention of undesired components of the furnish in the web will be reduced as compared with newsprint in which a filler is incorporated via conventional processes. The paper web formed via the process of the invention will have improved properties as a result of the incorporation of the pre-flocculated filler into the web.

**ABSTRACT**

Disclosed is a process for preparing a paper web. The paper web is prepared from a low-grade furnish, which contains low-grade pulps, such as recycled pulp and/or groundwood pulp, and which, in the preferred embodiment, is a newsprint furnish. In accordance with the disclosed process, a pre-flocculated filler is added to the furnish prior to forming the paper web from the furnish. Filler will be retained in the web, and retention of undesired components of the furnish in the web will be reduced as compared with newsprint in which a filler is incorporated via conventional processes. The paper web formed via the process of the invention will have improved properties as a result of the incorporation of the pre-flocculated filler into the web.

**PROCESS FOR PREPARING A PAPER WEB****TECHNICAL FIELD OF THE INVENTION**

5           The present invention is in the field of paper  
manufacturing. More specifically, the invention is  
directed towards a process for preparing a paper web, such  
as a sheet of newsprint, from low-grade paper furnishes.  
The invention further is directed towards a paper web  
10 prepared in accordance with the inventive process.

**BACKGROUND OF THE INVENTION**

Conventionally, paper is made by extracting a paper  
web from a slurry of wood pulp. In accordance with  
15 conventional paper-making processes, a furnish composed of  
wood pulp is provided and is introduced into a paper  
making machine. To the furnish are added various  
additives, the additives selected to affect the properties  
of the paper and the paper machine runnability. At the  
20 headbox of the paper making machine, pulp slurry from the  
headbox is deposited on a wire, and water is removed, thus  
forming a paper web from the slurry. The web is dried,  
optionally is collected on a reel, and subsequently is cut  
into sheets or otherwise converted for its intended  
25 application.

Generally speaking, paper may be classified into  
various grades, with higher grades of paper being known as  
"fine" papers, and with many lower grades also being  
known. The grade of paper is largely determined by the  
30 quality of the pulp in the paper furnish. One form of  
lower grade paper is newsprint, the paper stock that is  
used to print newspapers. Enormous quantities of  
newsprint are consumed daily by newspaper printers.  
Because of these high volumes and the short life  
35 expectancy of printed newspapers, printers and  
manufacturers of newsprint find it especially important to  
minimize the costs of newsprint stock, with cost generally  
being of somewhat more concern than paper quality. For

this reason, newsprint furnishes typically contain lower grades of wood pulp than are found in furnishes that are used for the production of fine papers. For example, newsprint stock typically contains large amounts of  
5 groundwood stock and/or recycled paper stock. Typically, at least 30% of the pulp found in newsprint furnishes is composed of groundwood stock and/or recycled stock, and in some instances, as much as 100% of the pulp in the newsprint furnish is so composed.

10 Both groundwood stock and recycled paper stock typically contain large amounts of impurities. Such impurities can adversely affect the quality of paper produced from such furnishes. For example, groundwood  
15 stock is typically prepared via the high-yield mechanical processing of raw wood. Such stock typically contains relatively large amounts of components that are undesirable in paper manufacture of paper, including such components as lignin, residue, pitch, resins,  
20 carbohydrates, fatty acids, and fine fibers. All of these components are believed to adversely affect various properties of the paper produced from groundwoods, the properties including those such as strength, brightness, color, opacity, smoothness, and printability. Similarly, recycled paper stock contains a number of undesired  
25 components, including chemical residues from prior paper processing, fine fibers, ink particles, and possibly other undesired components. These components are also believed to adversely affect the quality of paper prepared from such stock. Moreover, because the quality and  
30 composition of recycled paper stocks may vary from one source to another, the composition of recycled paper stock may be largely unknown. Accordingly, when recycled stock is provided in the newsprint furnish, additional difficulties in maintaining the quality of paper prepared  
35 from such furnishes are encountered.

Recycled stock and groundwood stock are sometimes used in smaller amounts in the manufacture of fine papers. In the manufacture of such papers, the prior art teaches

that the brightness, opacity, and other properties of the paper sheet may be improved by incorporating a filler into the paper furnish prior to forming a paper web therefrom. In conjunction with the preparation of such fine papers, fillers are believed to enhance the opacity, brightness, color, smoothness, and printability properties. In addition, fillers may be used to provide improved machine runnability and a reduction in sheet cost. Conventional fillers are composed of fine particles, such as clays, which are not easily retained as the paper web is being formed from the pulp slurry. Accordingly, the prior art teaches to add a retention aid to the slurry to assist in retaining the filler material within the paper web. The use of such fillers in connection with retention aids has been satisfactory in connection with the manufacture of fine papers.

In the manufacture of newsprint and similar paper webs from lower-grade furnishes, however, it is not commercially practical to use a retention aid to incorporate a filler into the paper product. Because relatively large amounts of lower grade pulps are present in newsprint furnishes, impurities and other undesired components associated with such pulps are present in relatively large amounts. Thus, when attempts are made to incorporate a filler into the newsprint web, relatively large amounts of impurities are found to be retained in the paper web along with the filler particles. The retention of such undesired components in addition to the filler particles has been found to largely or completely offset any benefits obtained by the incorporation of the filler into the paper web.

For these reasons, a need exists for a process for preparing a paper web from low-grade newsprint pulps while incorporating a filler into the paper web. The process should avoid the drawbacks associated with conventional methods of incorporating a filler into a paper web. It is a general object of the invention to provide a process for preparing a paper web from lower-grade furnishes that

include groundwood pulp, recycled pulp, or mixtures thereof, and for incorporating a filler into the paper web without also incorporating into the web amounts of impurities in the newsprint furnish that are sufficient to  
5 offset the benefits of incorporating the filler into the web. Another general object is to efficiently retain a filler in a newsprint web while maintaining the beneficial properties of the filler.

10

**SUMMARY OF THE INVENTION**

It has now been found that newsprint may be prepared from lower-grade pulp furnishes by adding a pre-flocculated filler to the furnish prior to forming a paper web therefrom. Surprisingly, it has also been found that,  
15 when filler is incorporated via the addition of a pre-flocculated filler, rather than by adding conventional filler and subsequently adding a retention aid, impurities such as lignin, pitch, ink particles, and other impurities commonly found in newsprint furnishes will not be  
20 incorporated into the paper web to the same degree as with the conventional process. Even more surprisingly, many properties of a newsprint sheet prepared from such furnishes are substantially improved as compared with those of conventionally prepared newsprint sheets.

25

Thus, the process of the invention includes the steps of providing a newsprint furnish, adding a pre flocculated filler to the furnish, and forming a paper web from the furnish. Typically, the web will be dried, printed with newspaper ink and subsequently cut into sheets. The  
30 invention also encompasses a paper web made in accordance with the foregoing premises.

In accordance with a particularly preferred embodiment of the present invention, the pre-flocculated filler is prepared in accordance with the teachings of  
35 U.S. Patent 4,799,964, issued to Richard D. Harvey et al. and assigned to Grain Processing Corporation of Muscatine, Iowa. The process for forming a pre-flocculated filler taught in the foregoing patent comprises continuously

bringing together an aqueous slurry of a paper filler material and a flocculating agent, and imparting to the mixture a shearing force sufficient to provide a flocculated filler of controlled particle size. When a pre-flocculated filler is prepared in accordance with the preferred embodiment of the invention and added to the newsprint furnish, a newsprint of high quality may be economically prepared.

10

#### DESCRIPTION OF THE DRAWINGS

Fig. 1 is a schematic representation of a conventional paper-making process.

15

Fig. 2 is a schematic representation of the process for preparing a paper web in accordance with the present invention.

#### DESCRIPTION OF THE INVENTION

The invention contemplates the preparation of newsprint and similar paper webs from newsprint furnishes. Newsprint furnishes are low-grade fibrous pulp slurries suitable for the production of newsprint, as opposed to fine papers. Typically, at least 30% of the pulp in the newsprint furnishes include groundwood pulp, recycled pulp, or mixtures thereof. The groundwood pulp in the furnish may be prepared from any suitable wood species. Recycled pulp may be any mechanically recycled pulp, thermomechanically recycled pulp, chemithermomechanical pulp, or other suitable recycled pulp furnish. Newsprint furnishes made from such low-grade pulps typically contain substantial amounts of lignin, resins, fatty acids, pitch, ink particles, chemical residues from prior paper processing, fine pulp fibers, and other undesired components, the components and amounts of such components sometimes being unknown. Such furnishes typically contain substantially larger amounts of such undesired components as compared to fine paper furnishes.

Fig. 1 represents a prior art process for the manufacture of fine paper. In accordance with this process, a fibrous pulp slurry 10 is provided. To the slurry 10 is added a filler at step 11. Subsequently, at  
5 step 12, a retention aid is added. Optionally, other additives are added to the slurry at step 14, the type and composition of these additives and their order of addition being conventional and within the level of skill in the art. At the headbox 15, a web 16 is formed from the  
10 furnish, and the whitewater is removed at step 17. In subsequent steps, the web 16 is dried (not shown), optionally rolled at step 18, and cut into sheets at step 19. The prior art teaches that this process may be used in the manufacture of fine papers. When fillers and a  
15 retention aid are added to a newsprint furnish in the manufacture of newsprint, however, substantial amounts of undesired components are retained in the paper web 16, thus detracting from the quality of the newsprint sheets ultimately prepared therefrom.

20 The process of the invention is represented in Fig. 2. In accordance with the invention, a pre-flocculated filler is added to the furnish prior to the headbox 15'. Preferably, pre-flocculated filler is added at the fan pump 20 or at other locations as close to the headbox as  
25 possible, but pre-flocculated filler may be added at any other suitable time. Filler that has not been pre-flocculated also may be added at any suitable time, although such generally is not preferred. As shown in Fig. 2, the process of the invention includes providing a  
30 newsprint furnish in the form of a fibrous pulp slurry at step 10', adding the pre-flocculated filler at step 21, and forming the paper web 16' from the slurry leaving whitewater, the whitewater being removed at step 17'. The web preferably is formed conventionally, that is, by  
35 depositing the slurry on a wire and removing the whitewater to thus form a web. The paper web may be dried (not shown) optionally rolled to form a paper roll at step 18', and subsequently cut into sheets at step 19'. The

web may be printed either before or after the web is cut into sheets. In the manufacture of newspapers, printed matter typically is applied to a roll of newsprint before the newsprint is cut into sheets and subsequently assembled to form a newspaper. Other additives may be added, for example at step 14', and otherwise the process may be conventional and practiced with conventional paper manufacturing equipment or otherwise as is suitable.

Preferably, the pre-flocculated filler is provided in accordance with the teachings of U.S. Patent 4,799,964. In accordance with this highly preferred embodiment of the invention, the process for preparing the flocculated filler comprises the steps of continuously introducing an aqueous slurry of a non-flocculated filler material and an aqueous slurry of from about 0.05% to about 60% by weight of the filler material of a flocculating agent into a shear imparting device, imparting to the mixture within the device a shearing force sufficient to provide flocculated filler particles of a size adapted for use in paper making, and continuously removing the flocculated filler particles from the shear imparting device. No additional treatment of pre-flocculated filler ordinarily will be required. However, while the pre-flocculated filler preferably is provided in accordance with the teachings of the foregoing patent, the pre-flocculated filler may be provided in accordance with any other suitable method, such as a batch method.

Any suitable filler material may be used in conjunction with the present invention. Preferred examples of conventional filler materials include clays, such as china clay, lithopone, sulfate fillers, pigments, such as titanium pigments, titanium dioxide, satin white, talc, calcium carbonate, barium sulfate, gypsum, chalk, and so forth. Particularly suitable fillers include kaolinitic clays, calcined clay, ground and precipitated calcium carbonate, and titanium dioxide. The choice of filler material is not critical to the invention, and may vary depending on the choice of one skilled in the art

based on criteria such as properties desired, availability, and cost. The ability to provide such filler and to retain it effectively in the paper web increases the papermaker's options in selecting a suitable  
5 filler.

Any suitable flocculating agent may be employed in preparing a pre-flocculated filler in conjunction with the invention. For example, conventionally known retention aids may be employed as flocculating agents. Flocculating  
10 agents are employed to flocculate together to the filler particles and the cellulosic fibers in the paper web. Generally, organic polymers of a high molecular rate are known to be useful as flocculating agents. Suitable flocculating agents include water-soluble vinyl polymers  
15 and gums, polacrylamides, aluminum sulfate, mannogalactanes, and anionic and cationic starch derivatives.

The anionic starch derivatives useful as flocculating agents generally are starch derivatives that contain  
20 substituent acid groups such as carboxyl, phosphate, sulfate, or sulfonate groups. Representative of such derivatives are sodium chloroacetate, phosphoryl chloride, sodium trimetaphosphate, and acid anhydrides, such as acetic, maleic, malonic, proprionic, and the like. Other  
25 starch derivatives also are useful as flocculating agents. For example, starch derivatives that contain primary, secondary, and or tertiary amino groups or a quaternary ammonium group may be used. The starches also can be cross-linked, dextrinized, oxidized, hydrolyzed,  
30 etherified, estherified, or otherwise modified. Cationic starch derivatives are regarded as preferred in connection with the invention. Representative of such cationic starch derivatives are starch derivatives having a degree of substitution (DS) in a range of about 0.01 to 0.15,  
35 preferably about 0.03 to about 0.075. Representative of such cationic starches include derivatives from chlorohydroxylpropyl trimethyl ammonium chloride, diethylaminoethyl hydrochloride, chlorylbutenyl trimethyl

ammonium chloride, 3-chloropropyltrimethylammonium chloride N-(3-chloro-2-hydroxypropyl) pyridinium chloride, ethyleneimine and the like. The invention is not limited to the foregoing starches, and anionic starches or  
5 amphoteric starches also are contemplated to be suitable for use in conjunction with the invention.

The amount of the flocculating agent used in conjunction with the invention can vary widely and, in general, any suitable amount may be used. For example,  
10 the flocculating agent can be present in an amount ranging from about 0.05% to about 60% by weight of the filler material. Preferably, the flocculating agent is present in an amount ranging from about 0.2 to about 4% by weight of the filler material. In connection with the pre-  
15 flocculation of the filler, the flocculated filler particle size can increase from about 2 times to about 50 times that of the unflocculated filler particle, and preferably from about 2.5 to about 25 times the original filler size. The preferred filler comprises clay and/or  
20 calcium carbonate that has been pre-flocculated with a cationic starch paste flocculating agent or polyacrylamide flocculant.

In accordance with the invention, the pre-flocculated filler is added to the pulp in an amount sufficient to  
25 impart at least one property to the paper web; and preferably is added in an amount sufficient to provide at least 1% by weight of filler in the paper web formed from the pulp slurry, at least a portion of this 1% filler in the web being present as a result of the addition of said  
30 pre-flocculated filler. The furnish may already have included some filler prior to addition of the pre-flocculated filler, especially when the newsprint furnish includes recycled pulp. Some of this filler may become incorporated into the paper web via mechanical entrapment  
35 or chemical retention. Thus, it is not necessary that all of the filler in the paper web be present as a result of the addition of the pre-flocculated filler to the furnish. Preferably, filler added as a result of the pre-

flocculated filler is present in the web in an amount ranging from about 1% to about 10% by weight, preferably from about 2% to about 5% by weight, with other fillers being present in an amount as small as is practical, preferably no more than about 2.5% to about 4% by weight. The total filler content of the web preferably is at least about 5% by weight, more preferably about 7.5% by weight. Preferably as the selection of relative flow rates of the paper furnish and of the pre-flocculated filler to achieve the desired filler retention is within the level of skill in the art. Typically, the pre-flocculated filler is added to the furnish in an amount ranging from about 80 lb/ton to about 200 lb/ton of dry furnish, preferably about 80 lb/ton to about 100 lb/ton in some applications.

Surprisingly, when a pre-flocculated filler is added to a newsprint paper furnish in accordance with the present invention, the retention of substantial amounts of impurities in the web is avoided. Enhancements in strength, brightness, opacity, and other properties of the newsprint sheets prepared from the paper web relative to paper that has not been prepared using a pre-flocculated filler may be realized.

The following examples illustrate the present invention, but should not be construed as limited in scope.

#### **EXAMPLE 1**

##### **Evaluation of Retention Characteristics**

This Example provides a comparative evaluation of the retention of filler and of undesired components as would be observed in the preparation of a paper web, as between the process of the invention and a conventional process.

##### **Preparation of Pre-Flocculated Filler**

Following the teachings of U.S. Patent 4,799,964, an aqueous slurry of clay at a dry solids content of 20% was pumped into a centrifugal mixing device at a rate of 3300

ml/min. Simultaneously, a 1% cationic polacrylamide-based flocculating agent was pumped into the mixture at a rate of 150 ml/min, thus resulting in a dry flocculant to dry filler add-on level of 0.2%.

5 Flocculated clay particles were produced continuously in the mixing device. The flocculated slurry was collected at the discharge of the mixing device. Using a Malvern Instruments Mastersizer particle size analyzer, the pre-flocculated filler was found to have a medium  
10 particle size of 13.87  $\mu$ , as compared to a medium particle size of 5.25  $\mu$  in the initial clay slurry.

#### Evaluation of Retention Characteristics

Using a Dynamic Drainage Jar, available from Paper  
15 Research Materials, Inc. of Syracuse, New York, the retention properties of the pre-flocculated filler were evaluated. The Drainage Jar was equipped with a 200-mesh screen. To the Drainage Jar was added a furnish prepared from a blend of thick stock and whitewater obtained from  
20 Jefferson Smurfit Company, Newberg, Oregon. The thick stock was a combination of approximately 50% mechanically pulped fiber, and 50% recycled fiber. The whitewater had been obtained from a paper machine making newsprint, and thus the whitewater included unretained components of the  
25 paper-making furnish. The stock pH was adjusted to 5.5 with sulfuric acid, and the ash level of the stock was found to be 9.6%.

A 500 ml charge of this combined furnish at approximately 0.50% consistency was added to the Drainage  
30 Jar under agitation of 750 rpm to provide a furnish in the jar. The pre-flocculated clay was added at 5%, or 100 lb/ton, on fiber from a 20% slurry. The 20% clay slurry was produced by diluting a 70% aqueous slurry with tap water. The clay was KAOFILL Kaolin, obtained from Thiele  
35 Kaolin Company, Sandersville, GA. No additional flocculant was added. The furnish was allowed to mix for 10 seconds prior to drainage. A 30 ml aliquot was collected and then discarded to ensure the collection of

an untainted sample for testing. Then, a 100 ml sample was collected, filtered, ashed, and analyzed for total retention and for filler retention.

For comparative purposes, a 500 ml charge of the dilute stock was added to the Drainage Jar at 750 rpm. Unflocculated clay was added at 5% on fiber from a 20% slurry. After allowing 10 seconds for mixing, the flocculating agent that had been used to form the pre-flocculated filler as set forth above was added as a retention aid. This retention aid was added at a level of 0.3 lb./ton (0.015%). The furnish was allowed to mix for an additional 5 seconds prior to drainage. A 30 ml aliquot was collected and discarded, and a 100 ml sample was then collected and analyzed for total retention and for filler retention. As a control, the experiment was repeated, except that unflocculated clay was added to the jar with no retention aid.

The total retention and filler retention were as follows:

20

TABLE I\*

	Total Retention	Filler Retention
Control (No flocculant)	21.55%	1.84%
Conventional Process (0.3 lb./ton total retention aid)	25.26%	11.57%
Pre-Flocculated Filler (0.2 lb/ton total flocculant)	21.76%	13.27%

\*Each retention value reported is the average of two tests.

25

This example illustrates that the use of pre-flocculated filler provides an increase in filler retention greater than that achieved with the conventional

process, which employed an unflocculated filler and subsequent addition of a retention aid. The pre-flocculated filler was able to achieve this result with 33% less flocculating agent than used in connection with the conventional process. Moreover, the use of a flocculated filler did not significantly affect non-filler retention as compared with the control, when no retention aid was employed.

10

**Example 2**  
**Evaluation of Retention Characteristics**

This Example provides a further comparative evaluation of the process of the invention as compared with a conventional process.

15

**Preparation of a Pre-Flocculated Filler**

In accordance with the procedure of Example 1, a clay slurry at 20% solids concentration was continuously mixed with a flocculant solution in the amount of 0.4% dry flocculant to dry filler add-on level. The resulting flocculated filler had a median particle size of 78.56  $\mu$ .

20

**Evaluation of Retention Characteristics**

Using a Dynamic Drainage Jar and the paper stock used in Example 1, pre-flocculated filler was added to the stock in an amount of 0.4 lb. flocculating agent per ton furnish (0.020%). No additional flocculating agent was added.

25

For comparative purposes, unflocculated clay was added to a Dynamic Drainage Jar. The flocculating agent that had been used in the preparation of pre-flocculated filler was added as a retention aid. The retention aid was added at a level of 0.4 lb. flocculating agent per ton furnish (0.02%). As a control, unflocculated filler was added to the jar without using a retention aid.

30

35

Total retention, filler retention, and non-filler retention were evaluated, and the following results were obtained:

TABLE 2

	Total Retention	Filler Retention	Non Filler Retention
Control	21.6%	1.8%	27.5%
Conventional	25.4%	10.3%	30.0%
Pre-Flocculated Filler	24.1%	13.0%	27.4%

5 These results illustrate that the flocculated filler provides a significant increase in filler retention as compared to the conventional process. Surprisingly, non-filler retention did not significantly change as between the flocculated filler and the control, and non-filler retention was less for the process of the invention as compared with that of the conventional process.

### EXAMPLE 3

#### Preparation of Handsheets and Brightness Evaluation

15 This Example illustrates the preparation of handsheets and the evaluation of the brightness (GE Scale) of the handsheets.

20 In accordance with the procedures set forth in Example 1, pre-flocculated clay filler was prepared. The flocculated clay filler was added to a 500 ml charge of furnish in a Dynamic Drainage Jar at 750 rpm agitation. Filler was added at 5% on fiber containing the equivalent of 0.2 lb. flocculant per ton furnish (0.010%). After applying the furnish to the filler within the Dynamic Drainage Jar, the charge of stock was immediately transferred to a handsheet apparatus, and a handsheet was formed. The sheet was pressed twice at 5 minutes and at 2 minutes, dried on drum dryer at 100° F (38° C) for approximately 20 minutes, and allowed to cure overnight in a constant temperature/humidity room. A second handsheet

was prepared using 10% flocculated clay filler. For comparative purposes, similar handsheets were formed using comparable amounts of filler and adding the flocculating agent as a retention aid after the filler was added to the furnish in the Dynamic Drainage Jar. Control handsheets were also prepared without the addition of filler or retention aid to the jar.

Each set of handsheets was analyzed for GE brightness, and for filler content. From these results, brightness values for a given ash value for flocculated, unflocculated, and zero virgin filler addition were evaluated for comparison with the control handsheet. The following results were obtained:

TABLE 3

	PERCENT SHEET FILLER CONTENT	BRIGHTNESS (GE Scale)
<b>Flocculated Filler</b>	7.3% Interpolated (3% Virgin)	53.2
<b>Non-flocculated Filler</b>	7.3% Interpolated (3% Virgin)	51.2
<b>Control - No Virgin Filler</b>	4.3% (0% Virgin)	52.2

These results demonstrate that the use of an unflocculated filler with a retention aid in accordance with conventional teachings causes the brightness to drop in comparison to the control handsheet wherein no retention aid is used. This drop in measured brightness is believed to be due to the retention of unwanted components of the furnish in the sheet. Surprisingly, and in contrast, the use of a pre-flocculated filler in accordance with the process of the invention caused a significant increase in measured brightness. This increase in brightness is believed to be due to the presence of filler in the sheet, and to the fact that undesirable components of the furnish were not

incorporated in amounts sufficient to offset the benefits of the retention of filler.

5

**EXAMPLE 4**  
**Preparation of Handsheets and**  
**Evaluation of Strength Properties**

Handsheets were prepared in accordance with Example 3. Each of the handsheets was analyzed for strength properties, including Scott bond strength and Mullen strength. The results were interpolated to a given filler content to compare with the control. The following results were obtained:

15

**TABLE 4**

	Filler Content	Scott Bond	Mullen
<b>Control</b>	4.3% (0% Virgin)	119.4	7.5
<b>Non-flocculated Filler</b>	7.3% Interpolated (3% Virgin)	126.5	17.5
<b>Flocculated Filler</b>	7.3% Interpolated (3% Virgin)	127.8	18.5

These results indicate that the use of a pre-flocculated filler provides a paper web with improved Scott bond strength and Mullen bursting strength, as compared with a web prepared in accordance with the conventional process and a web prepared with no retention aid.

25

**EXAMPLE 5**  
**Preparation of Handsheets and Evaluation of Opacity**

Handsheets were prepared in accordance with Example 3, and the opacity of the handsheets was evaluated. The following results were obtained:

30

TABLE 5

	Filler Content	Opacity
Control	4.3% (0% Virgin)	97.30
Non-flocculated Filler	7.3% Interpolated (3% Virgin)	97.97
Flocculated Filler	7.3% Interpolated (3% Virgin)	98.23

5 These results indicate that the process of the invention provides an increase in opacity greater than can be obtained at equivalent filler levels with a conventional process.

EXAMPLE 6

10 Handsheets prepared in accordance with Example 3 were tested for caliper and for porosity using a Gurley Densimeter. The following results were observed:

TABLE 6

	Filler Content	Caliper	Porosity
Control	4.3% (0% Virgin)	6.03	89.48
Non-flocculated Filler	7.3% Interpolated (3% Virgin)	8.86	88.64
Flocculated Filler	7.3% Interpolated (3% Virgin)	6.29	96.4

15 The significantly greater caliper observed with the conventional process was believed to be due to bundling of fibers and poor sheet formation. Similarly, the loss of porosity of the sheet prepared in accordance with the conventional process was believed to be due to poor sheet  
20 formation. As is known in the art, as sheet formation deteriorates, the sheets tends to become more porous; similarly, it is known that a change in caliper is an indication of a significant change in formation. The relatively poor quality of sheet formation of the sheet

prepared by the conventional process was confirmed by visual inspection.

In contrast to the conventional process, the process of the invention provided a handsheet with a surprising slight increase in caliper and decreased porosity as compared to the control handsheet. The handsheets were visually inspected, and the handsheets that were prepared in accordance with the present invention appeared to be better formed as compared with the control sheet and that prepared in accordance with the conventional process. These improved properties enhance both paper printability and print quality of the paper sheets.

Thus, it is seen that the foregoing general objects have been satisfied. The invention provides a process for incorporating a filler into a newsprint or other low-grade furnish by using a pre-flocculated filler. Surprisingly, when a web of paper is prepared from the furnish, many properties of the web are improved as compared with webs that have been otherwise prepared. The process of the invention is useful not only in the preparation of handsheets, but also in large-scale newsprint manufacturing operations.

While particular embodiments of the invention have been shown, it will be understood that the invention is not limited thereto since modifications may be made by those skilled in the art, particularly in light of the foregoing teachings. It is, therefore, contemplated by the appended claims to cover any such modifications as incorporate those features which constitute the essential features of these improvements within the true spirit and scope of the invention.

We Claim:

1. A paper web prepared by a process comprising the steps of:
  - providing a pulp slurry, said slurry containing at least about 30% by dry pulp weight of a low-grade pulp, said low-grade pulp being a pulp selected from the group consisting of a groundwood pulp, a recycled pulp, and mixtures thereof;
  - adding a pre-flocculated filler to said slurry;
  - forming a paper web from said slurry; and
  - winding said web on a reel;

said pre-flocculated filler being added to said slurry in an amount effective to provide a filler content in said web, at least a portion of said filler in said web comprising said pre-flocculated filler, wherein said pre-flocculated filler is selected from the group consisting of clays, lithopone, sulfate fillers, titanium pigments, talc, calcium carbonate, and gypsum, wherein said pre-flocculated filler has been prepared by steps of:

  - continuously introducing an aqueous slurry of a non-flocculated paper filler material and an aqueous slurry of from 0.5 to 60% by weight of the filler material of a flocculating agent into a shear imparting device and imparting to the mixture within said device a shearing force sufficient to provide flocculated filler particles of a size adapted for use in paper making without any additional treatment and continuously removing said flocculated filler particles from the shear imparting device, said particle size being in the range from 38 to 75 micron.
2. The paper web according to claim 1, the process further comprising the steps of:
  - drying said web; and
  - cutting said web into sheets.
3. The paper web according to claim 2, the process further comprising the step of:
  - printing on said web prior to cutting said web into sheets.
4. A newspaper prepared by a process comprising the steps of:
  - providing a newsprint pulp slurry;
  - adding a pre-flocculated filler to said slurry;

wherein said pre-flocculated filler is selected from the group consisting of clays, lithopone, sulfate fillers, titanium pigments, talc, calcium carbonate, and gypsum, wherein said pre-flocculated filler has been prepared by steps of:

continuously introducing an aqueous slurry of a non-flocculated paper filler material and an aqueous slurry from 0.5 to 60% by weight of the filler material of a flocculating agent into a shear imparting device and imparting to the mixture within said device a shearing force sufficient to provide flocculated filler particles of a size adapted for use in paper making without any additional treatment and continuously removing said flocculated filler particles from the shear imparting device, said particle size being in the range from 38 to 75 micron,

forming a paper web from said slurry, said pre-flocculated filler being added to said slurry in an amount effective to provide a filler content in said web, at least a portion of said filler in said web comprising said pre-flocculated filler;

collecting said web on a reel, and in either order:

printing on said web; and

cutting said web into sheets.

5. The newspaper according to claim 4, wherein said web is cut into sheets after said step of printing on said web.

6. A paper web prepared by a process comprising the steps of:

providing a pulp slurry, said slurry containing at least about 30% dry pulp weight of a low-grade pulp, said low-grade pulp being a pulp selected from the group consisting of a groundwood pulp, a recycled pulp, and mixtures thereof;

adding a pre-flocculated filler to said slurry to thereby form a slurry/filler mixture;

introducing said slurry/filler mixture to the headbox of a paper-making machine;

depositing said slurry on a web-former; and

withdrawing a paper web from said headbox;

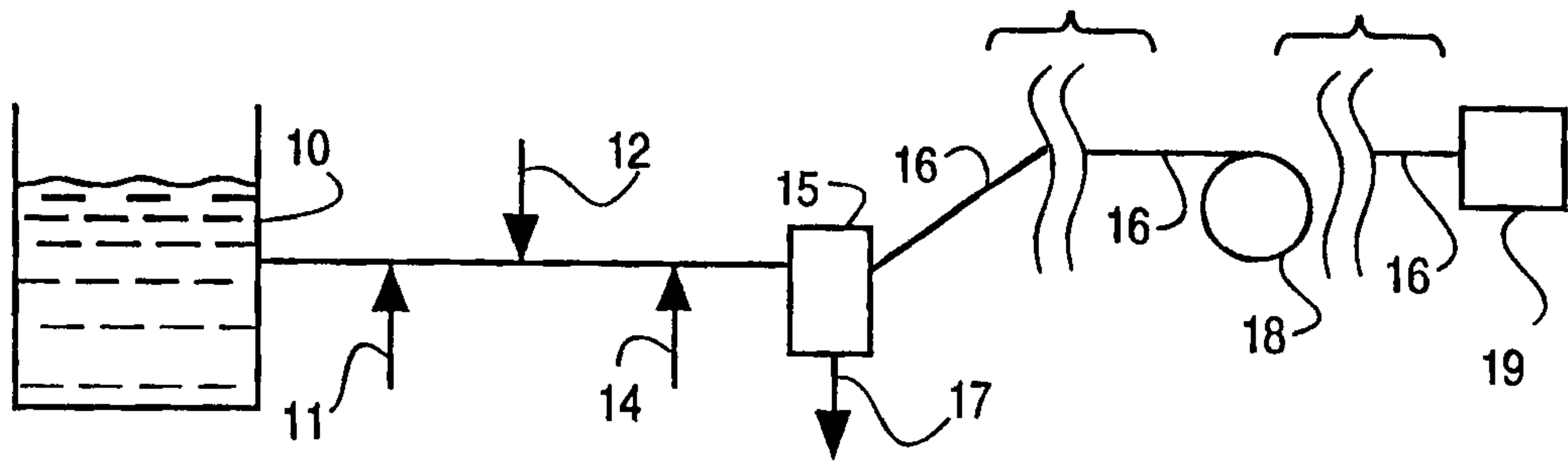
said pre-flocculated filler being added to said slurry in an amount effective to provide a filler content in said web, at least a portion of said filler in said web comprising said pre-flocculated filler, wherein said pre-flocculated filler is selected from the group consisting of clays, lithopone, sulfate fillers, titanium pigments, talc, calcium carbonate, and gypsum, wherein said pre-flocculated filler has been prepared by steps of:

continuously introducing an aqueous slurry of a non-flocculated paper filler material and an aqueous slurry of from 0.5 to 60% by weight of the filler material of a flocculating agent into a shear imparting device and imparting to the mixture within said

**device a shearing force sufficient to provided flocculated filler particles of a size adapted for use in paper making without any additional treatment and continuously removing said flocculated filler particles from the shear imparting device, said particle size being in the range from 38 to 75 micron.**

- 7. The paper web according to claim 6, the process further comprising the steps of:  
drying said web; and  
cutting said web into sheets.**
- 8. The paper web according to claim 7, the process further comprising the step of:  
printing on said web prior to cutting said web into sheets.**

**FIG. 1**  
PRIOR ART



**FIG. 2**

